

9/5/2019

303 H 1/2

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3622-1

Job Sheet 199958



Part No: D3622-1

Job Qty: 10 pcs

Part Name: Ball Stud



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/5/19

Job Tracking No:

Due Date: 11/18/19

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG REV D IPP Rev:A New Issue 07-04-24 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	10 pcs	11/18/19	11/18/19	0.50	1.30	Hardinge - 1		B7 19-09-27 JBD
110	QC 2	10 pcs	11/18/19	11/18/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		



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CANADA
TEL: 1 613 632-5200
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Container No: S217501



Part: D3622-1

Job No: 199958

Serial No/Batch: S217501

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/27/19

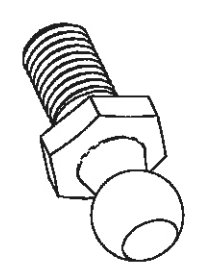
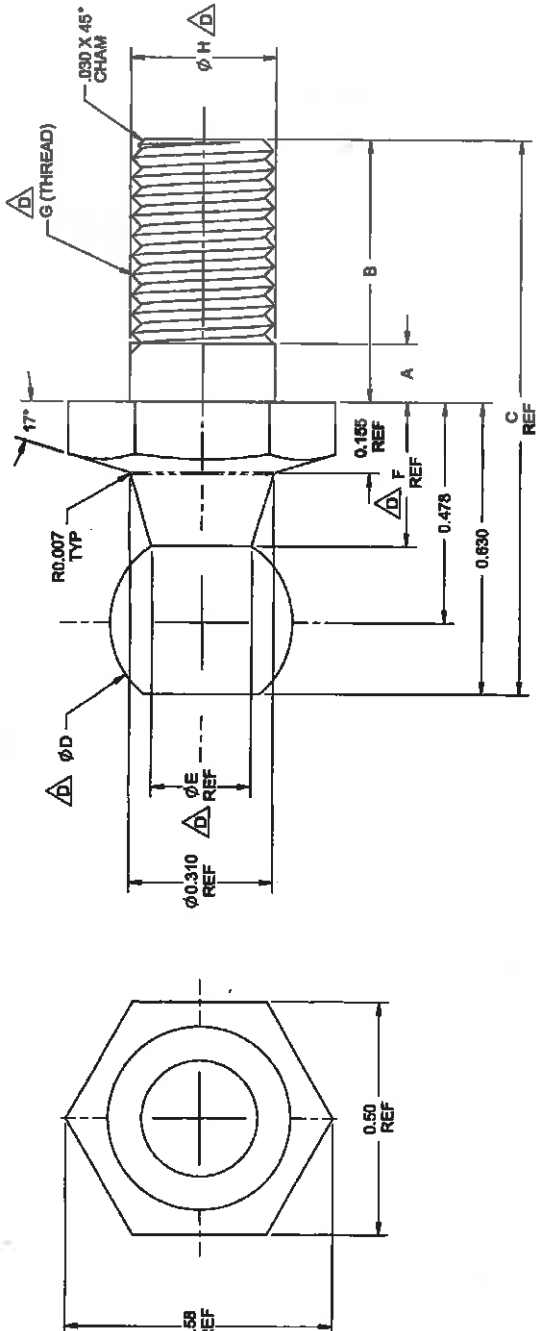
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					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	JBD 19/09/17
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	19/09/28
120 QC 8	10 pcs	11/18/19	0.00 0.00		QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
130 Packaging 3-1 - Stock - B4B	10 pcs	11/18/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B ✓	ST 043
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	

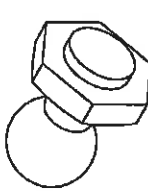
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	10 pcs	11/18/19	0.00 0.00	QC 21 - SA - 21 ✓	ST 043
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - (Hardinge) 1-TURN AS PER FOLIO FA686 & DWG D3622 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check) 130 - (Identify as per dwg & Stock Location: _____) 140 - (QC21- Final Inspection - Work Order Release)					DAS 21 8-89 SEP 30 2019
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M303H0.500	303 Hex Bar .500	1.0800 ft (.108 ea)	100-Hardinge - 1	590989	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Hardinge - 1	M303H0.500	1	10	0	
Part Specifications					
Specifications could not be found.					

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8 7 6 5 4 3 2 1



D3622-1 BALL STUD SHOWN



D3622-11 BALL STUD SHOWN

PART NUMBER	DIM A	DIM B	DIM C	DIM D	DIM E	DIM F	WEIGHT (LBS)	THREAD	MIN	MAX
D3622-1	0.125	0.563	1.19	0.394	0.215	0.313	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-3	0.125	0.563	1.19	0.394	0.215	0.313	0.03	0.1875-32UNF-3A	0.1840	0.1900
D3622-5	0.090	0.900	1.53	0.394	0.215	0.313	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-7	0.090	0.900	1.53	0.394	0.215	0.313	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-9	0.090	1.180	1.79	0.394	0.215	0.313	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-11	0.090	N/A	0.89	0.394	0.215	0.313	0.02	NOT THREADED	0.270	0.300
D3622-13	0.090	0.690	1.31	0.394	0.215	0.313	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-15	0.090	0.430	1.06	0.350	0.202	0.334	0.02	M6 X 1.0	5.82mm	6.00mm

D3622-X BALL STUD

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 199958

- NOTES:
- 1) MATERIAL: AISI 303 HEX BAR
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENT PIN D3622-X & B/N PER QSI 044
 - 7) WEIGHT: SEE D3622-X TABLE

RELEASED
2016-04-18
16-57

APPROVED

D	ADDED -15, ADDED COLUMN D, E AND F, RENAMED SUBSEQUENT COLUMNS.	AK	16.03.15
C	SHEET 1: ADD -5, -7, -9, -11 & -13. ADD D3622-X TABLE. SHEET 2 DELETED	JPH	10.07.20
B	ADD -3 (SHEET 2)	HS	06.06.18
A	NEW ISSUE	MS	07.04.13
REV.	DESCRIPTION	BY	DATE
DRAWN	JPH	AK	
CHECKED	VS		
MFG. APPR.	JL		
APPROVED	HS		
DE APPR.	DS		
DATE	16.03.15		
DART AEROSPACE LTD HAYMESBURY, ONTARIO, CANADA			
DRAWING NO. D3622			
SHEET 1 OF 1			
TITLE BALL STUD			
SCALE NTS			
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INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD	
B	10.02.02	Dwg Rev updated	KJ	
C	11.02.18	Dimensions updated per Dwg Rev C	KJ	
D	16.06.24	Dwg Rev updated	KJ	
E	16.10.13	Dimensions updated	KJ	